



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T102137-101-105
Job Sheet 197082



21
9-89

Part No: RB T102137-101-105

Job Qty: ~~4 pcs~~ **8 pcs.**

Part Name: Pin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/28/19

Job Tracking No:

Due Date: 7/15/19

Created By: Kimberley Guerin

Type: SOLD

Description:

Note: DWG RB T102137-101 Rev E IPP Rev. A 19.06.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	SL-154 - 1	4 pcs	7/15/19	7/15/19	1.00	0.67	SL-154 - 1		JB 19-06-29
120	QC 2	4 pcs	7/15/19	7/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		JB 19-06-29
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1-813-632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S194915



Part: RB T102137-101-105

Job No: 197082

Serial No/Batch: S194915

Revision: E

Inspector:

Exp Date:

DAS
62
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150 QC 8	4 pcs	7/15/19	0.00 0.00	QC 2 - 5		
				QC 2 - 71		
				QC 2 - 73		
				QC 2 - 69		
				QC 8 - 12		
				QC 8 - 14	7/19/07/02	
				QC 8 - 17		
				QC 8 - 20		
				QC 8 - 25		
				QC 8 - 3		
				QC 8 - 32		
				QC 8 - 33		
				QC 8 - 35		
				QC 8 - 39		
				QC 8 - 4		
				QC 8 - 44		
				QC 8 - 45		
				QC 8 - 49		
				QC 8 - 58		
				QC 8 - 8		
				QC 8 - 9		
				QC 8 - 68		
				QC 8 - 67		
				QC 8 - 1 (A)		
				QC 8 - 47		
				QC 8 - 40		
				QC 8 - 52		
				QC 8 - 23		
				QC 8 - 57		
155 Outsource - 1 - Heat Treat	4 pcs	7/15/19		MEI001-VC	12	2019-07-03
157 Packaging 2-1 - Receive - B4B	4 pcs	7/15/19	0.00 0.00	Packaging 2 - 1 - B4B		
				Packaging 2 - 2 - B4B		
				Packaging 2 - 3 - B4B		
				Packaging 2 - 5 - B4B		
				Packaging 2 - 4 - B4B	JUL 09 2019	
				Packaging 2 - 6 - B4B		
				Packaging 2 - 7 - B4B		
				Packaging 2 - 8 - B4B		
				Packaging 2 - 9 - B4B		
				Packaging 2 - 10 - B4B		
				Packaging 2 - 11 - B4B		
				Packaging 2 - 12 - B4B		
				Packaging 2 - 13 - B4B		
				Packaging 2 - 14 - B4B		
				Packaging 2 - 15 - B4B		
				Packaging 2 - 16 - B4B		
				Packaging 2 - 17 - B4B		
				Packaging 2 - 18 - B4B		
				Packaging 2 - 19 - B4B		
				Packaging 2 - 20 - B4B		
				Packaging 2 - 21 - B4B		
				Packaging 2 - 22 - B4B		
				Packaging 2 - 23 - B4B		
				Packaging 2 - 24 - B4B		
				Packaging 2 - 25 - B4B		
				Packaging 2 - 26 - B4B		
				Packaging 2 - 27 - B4B		
				Packaging 2 - 28 - B4B		
				Packaging 2 - 29 - B4B		
					Plex 6/28/19 9:03 AM Dart.Guerin.Kimberley	

					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
205 QC 6	4 pcs	7/15/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
210 Packaging 3-1 - Stock - B4B	4 pcs	7/15/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
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					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
220 QC 21 - SA	4 pcs	7/15/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

DAS
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9-89

JUL 09 2019

GA 150A

DAS
21
9-89

JUL 11 2019

Part Op 110 - MORI SL-154 LATHE - 1-Machine as per folio FC 830 FOLIO REV: AA DWG REV: E 2-

Descriptions: Debur

120 - QC2- Inspect parts off machine FAI/FAIB

150 - QC8- Inspect parts - second check

155 - 1-Issue P/O; 43899 RC 48-52 2-Bead blast 3--Material type; O1 4- Certificate of Conformity is required

157 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs)

205 - QC6- All purchased or subcontracted products ***NOTE*** Zinc plating to be done after load test at final assembly.

210 - Identify as per dwg & Stock Location: _____

220 - QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-O1-R0.625	Tool Steel Round Bar 0.625 dia.	1.6000 ft (.4 ea)	110-SL-154 - 1	S134211 S142241
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	MT-O1-R0.625	2	7	0
Part Specifications				
Specifications could not be found.				

Plex 6/28/19 9:03 AM Dart.Guerin.Kimberley

RBT 102137 - 101 - 105

[illegible]

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043899



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Attention: Bejenaru, Livia

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043899

PO Date: 7/3/19

Due Date: 7/19/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
2019-07-04

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197082	RB T102137- 101-105	Pin 1-Issue P/O; RC 48-52 2-Bead blast 3--Material type; O1 4- Certificate of Conformity is required	Firmed	-	7/9/19	8 pcs	0 pcs	8 pcs	\$79.875/pcs	\$639.00
Line Item Note **EXPEDITE** 8X JUL 09 2019											
2	196938	D5504-1	Blade PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed	-	7/19/19	16 pcs	0 pcs	16 pcs	\$19.375/pcs	\$310.00
Grand Total:										\$949.00	

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

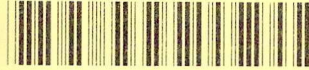
Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
337772	1	138567

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
hb043899		O1	2019/7/3	CLIENT

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
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8 RB-T102137-101-105 2,
(8) RB-T102137-101-105
JOB 197082

1 BOITE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

certificat

EXPÉDIÉ PAR: Shipped by:	
-----------------------------	--

RECEIVED
JUL 09 2019
DART AEROSPACE LTD.

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 8
POIDS EXPÉDIÉ / Weight Shipped : 2,00
QUANTITÉ RESTANTE / Quantity Remaining : 0
POIDS RESTANT / Weight Remaining : 0,00

APPROUVÉ
AG 7/8

certificat

QUANTITÉ EXPÉDIÉE / Quantity Shipped:	8
POIDS EXPÉDIÉ / Weight Shipped :	2,00

Signature:

Date:

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
337772	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
hb043899	N/A	O1		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SEL HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	48 - 52 HRC	8 (907)	51 - 52 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
8	2	RB-T102137-101-105 (8) RB-T102137-101-105 JOB 197082 1 BOITE DE CARTON

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2019-07-08

Pierre Piché
Chief Inspector

METCOR
6

APPROUVÉ
ACCEPTED

METCOR INC.

500 BUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J1R 5A8
 Tél: 450-473-1884
 Télécopieur / Fax administration: 450-491-2498
 Télécopieur / Fax production: 450-491-0124

Certificat de Conformité Certificate of Compliance	
BON DE TRAVAIL order	337775
CHARGEMENT load	1

CLIENT / customer: 215
 DART AEROSPACE
 1270 ABERDEEN
 HAWKESBURY
 ON K8A 1K7

LIVRE À / shipped to:
 DART AEROSPACE
 1270 ABERDEEN
 HAWKESBURY
 ON K8A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIÈCE part classification	MATÉRIEL material	MAÎTRE D'ŒUVRE prime contractor	PROGRAM
HP043889	N/A	01		
SELF HARDEN HARDEN AND TEMPER SPECIFICATIONS / spécifications PROCESSING SPECIFICATIONS SPÉCIFICATIONS / spécifications TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results EXIGENCE / requirement 48 - 52 HRC 8 51 - 52 HRC (907)				
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
8	2	1 BOITE DE CARTON JOB 187082 (8) RB-T102137-101-108 RB-T102137-101-108		

COMMENTAIRES / comments

APPROUVÉ par / Approved by:	DATE: 2019-07-08
-----------------------------	------------------

Pierre Pichon
 Chief Inspector
 METCOR

APPROUVÉ

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
337772	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

1

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
hb043899	N/A	O1		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SEL HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified		TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	48 - 52 HRC		8	51 - 52 HRC
(907)				
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
8	2	RB-T102137-101-105 (8) RB-T102137-101-105 JOB 197082 1 BOITE DE CARTON		

COMMENTAIRES / comments

SALT HARDEN 1475°F - 40 MINS

TEMPER 750°F - 2:00 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification.

All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée.

Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
337772	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

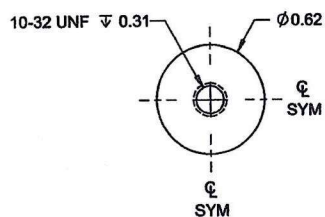
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APPROUVÉ par / Approved by:

DATE: 2019-07-08

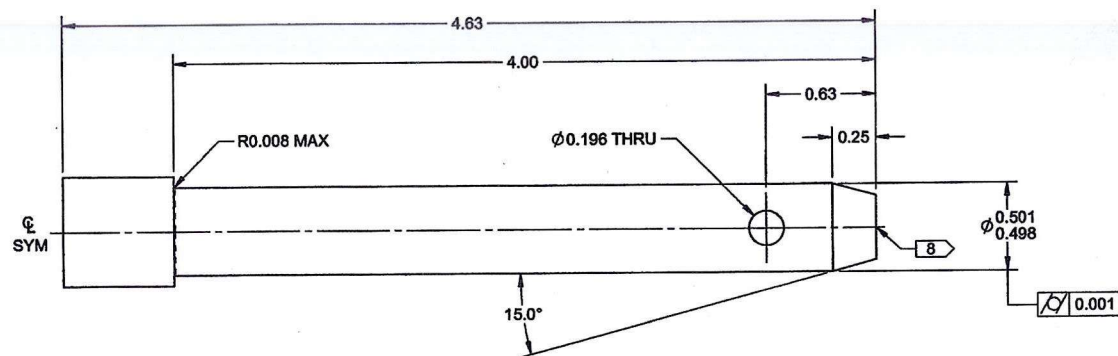
Lucie Desmarais
QA Technician





RB T102137-101-105 PIN

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NOTES:

- 1) MATERIAL: O1
- 2) HEAT TREAT: 48-52 RC
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
 X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
 X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
 X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE
- 9) DIMENSIONS MUST BE MET AFTER PLATING

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RB T102137-101 TITLE LIFTING TOOL COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV E
DRAWN	KPT		SHEET 3 OF 6
CHECKED	MBB		SCALE
MFG. APPR.	JFC		NTS
APPROVED		DATE	2019-06-20